

Work Order ID 58552

May 11, 2010 10:29:23 AM



Page 1

| | | | | | | |
|----------------|------------|------------|-------|-------|-------|--|
| Item ID: | D3443-9 | Accept | | Setup | Start | |
| Revision ID: | | | | | | |
| Item Name: | Pin | | | Stop | | |
| Start Date: | 11/05/2010 | Start Qty: | 30.00 | | | |
| Required Date: | 18/05/2010 | Req'd Qty: | 30.00 | | | |
| Reference: | | | | | | |
| | | | | | | |

| | | | | | | | | | | | |
|------------|---------------|--|-------|---------|------------|--|-------|--|-----|-------|--|
| Approvals: | Process Plan: | | Date: | 10-5-11 | Tooling: | | Date: | | Run | Start | |
| | QC: | | Date: | | SPC (Y/N): | | Date: | | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3443 | Rev C |

| | | | | | | | | | |
|--------------------------|--|------|--|--|--|--|--|--|--|
| 100 | | 0.00 | | | | | | | |
| | Hardinge CNC LATHE SMALL | | | | | | | | |
| Hardinge | Memo | 0.00 | | | | | | | |
| Hardinge CNC Lathe Small | 1-TURN AS PER FOLIO FA698 & DWG D3443 , □FOLIO REV: <u>C</u> □DWG REV: <u>e</u> □2-DEBURR AS REQUIRED | | | | | | | | |

SN 10/05/14

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 110 | | 0.00 | | | | | | | |
| | QC2- Inspect parts off machine FAI/FAIB | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

SN 10/05/14

| | | | | | | | | | |
|-----------------|-----------------------------------|------|--|--|--|--|--|--|--|
| 120 | | 0.00 | | | | | | | |
| | QC8- Inspect parts - second check | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

N.A 10/05/14

30 0

30 0

30 0

| W/O: | | | WORK ORDER CHANGES | | | | | |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | |
|------|------|--------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 58552

May 11, 2010 10:29:23 AM



Page 2

Item ID: D3443-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Pin

Start Date: 11/05/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 18/05/2010 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location 50

0.00



Packaging

Memo

0.00

Packaging

10-5-24 (30) X SP

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/17 JG
P/10-5-167
(30)

| W/O: | | | WORK ORDER CHANGES | | | | | |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

May 11, 2010 10:29:27 AM

Page 1

Work Order ID: 58552



Parent Item: D3443-9



Parent Item Name: Pin

Start Date: 11/05/2010

Required Date: 18/05/2010

Comments: IPP rev A 05.12.19 new issue ec

Start Qty: 30.00

Required Qty: 30.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|
| MDELNR0.500 | | Purchased | No | | | 110 | f | 114.0000 | 0.0875 | | | |
| | | | | | | | | | | | | |
| Delrin Round Bar .50" | | | | | | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT050 | 114 | |
| 102828 | 2 | |
| 109571 | 45 | |
| 18355 | 64 | |
| 3723 | 3 | |

3RF SD 10/05/14

2.3RF

| W/O: | | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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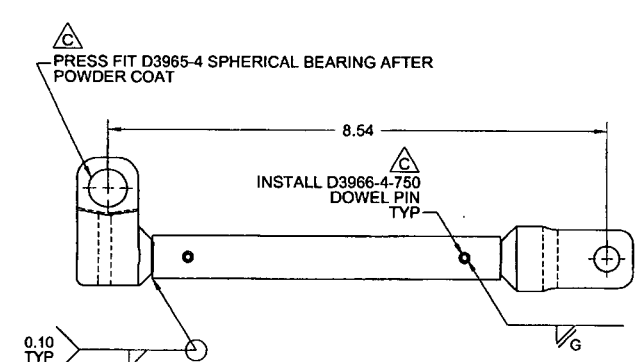
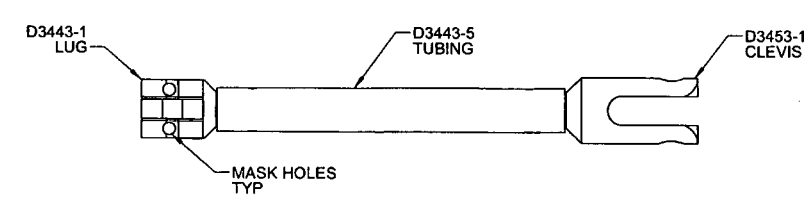
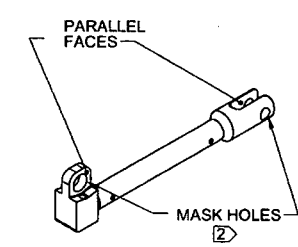
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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3443-041

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.33 lbs
 - 8) WELD PER DART QSI 004

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-------------|-------------------------|
| 1 | X | D3443-041 | STRUT WELDMENT ASSEMBLY |
| 2 | 1 | D3443-1 | LUG |
| 3 | 1 | D3443-5 | TUBING |
| 4 | 1 | D3453-1 | CLEVIS |
| 5 | 1 | D3965-4 | BEARING, SPHERICAL |
| 6 | 2 | D3966-4-750 | PIN, DOWEL |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58552
PS10-5-4

RELEASED
09/08/25 M

| C | DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.581 WAS 0.451 (ZN C1-3); R0.219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENAUER P/N (ZN C6-1, B5-2); D3966-4-750 WAS MCMASTER-CARR P/N (ZN B5-1); REF PAR 09-018 | RF | 09.06.25 |
|------------|---|----|----------|
| B | ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE: & Ø 0.125 WAS #30 | RF | 05.12.05 |
| A | NEW ISSUE | RF | 05.09.02 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | | |
| DRAWN | RF | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 09.06.25 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3443

TITLE
STRUT WELDMENT ASSEMBLY NTS

REV. C
SHEET 1 OF 4
SCALE

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8 7 6 5 4 3 2 1

| W/O: | | | WORK ORDER CHANGES | | | | | |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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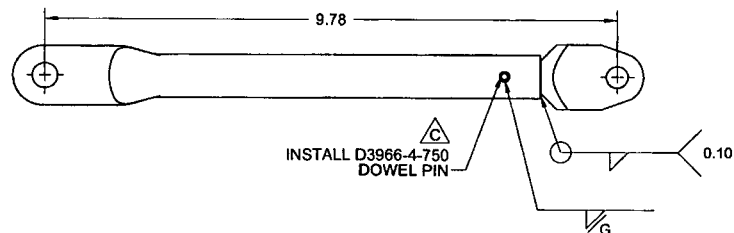
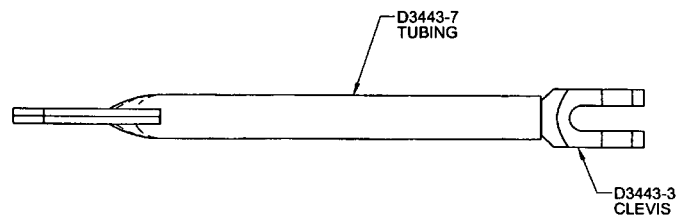
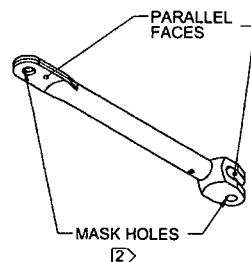
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| ITEM | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|-------------------------|
| 1 | X | D3443-043 | STRUT WELDMENT ASSEMBLY |
| 2 | 1 | D3443-3 | CLEVIS |
| 3 | 1 | D3443-7 | TUBING |
| 4 | 1 | D3966-4-750 | PIN |



D3443-043

W/C 58552

RELEASED
9/16/25/14

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

| | | | |
|------------|----------|---|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. D3443 | REV. C |
| MFG. APPR. | | | SHEET 2 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | STRUT WELDMENT ASSEMBLY | NTS |
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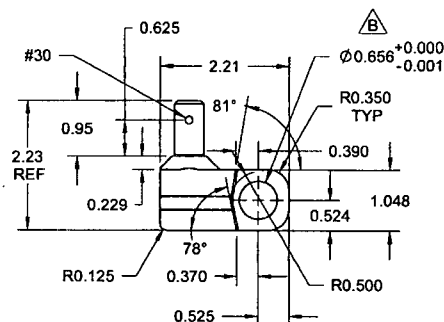
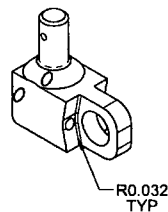
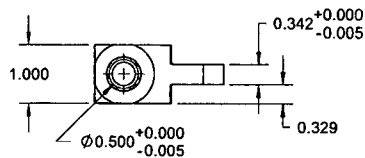
| W/O: | | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

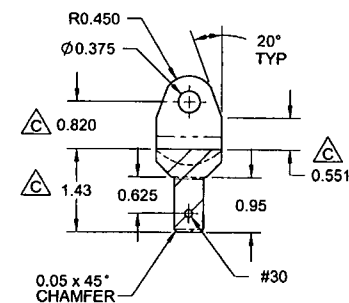
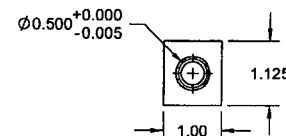
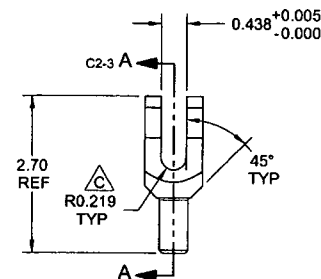
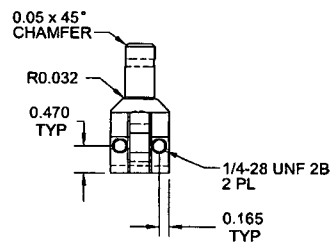
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D3443-1 LUG



SECTION A-A C4-3

D3443-3 CLEVIS

w/058552

RELEASED
07/28/25/11

NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

| | | | |
|--|--------------------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. C |
| MFG. APPR. | <i>[Signature]</i> | D3443 | SHEET 3 OF 4 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | STRUT WELDMENT ASSEMBLY | NTS |
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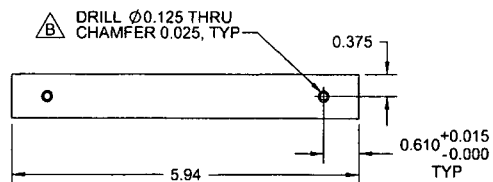
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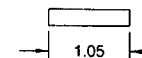
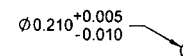
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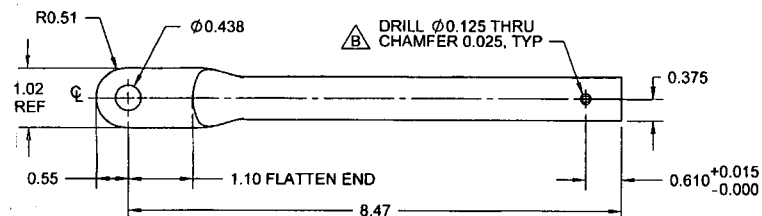
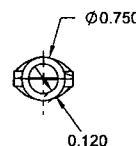
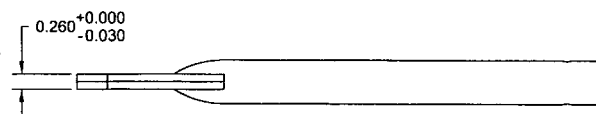
D3443-5 TUBING



D3443-9 PIN

D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3443-7 TUBING

D3443-5/7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

celo 58552

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| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>RF</i> | DRAWING NO. | REV. C |
| MFG. APPR. | <i>[Signature]</i> | D3443 | SHEET 4 OF 4 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
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NOTE: Date & initial all entries